

Date: Tuesday, 7/1/2008 2:34:27 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PEDAL LOCK
Job Number	: 40190		
Estimate Number	: 12342		
P.O. Number	:	Part Number	: D3368041
This Issue	: 7/1/2008 S.O. No. :	Drawing Number	: D3368 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: B
Previous Run	: 37182	Material	:
Written By	:	Due Date	: 7/30/2008
Checked & Approved By	: <u>08.07.01</u>	Qty:	6 Um: Each
Comment	: Est Rev:A Removed from 9 Digit 06-03-22 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D33681	Pedal Lock Base
-----	--------	-----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3368-1 BASE B23534B40205

SQ

2.0	D33683	Pedal Lock Cover
-----	--------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3368-3 COVER B40206

SQ

3.0	D27287	Label
-----	--------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2728-7 Decal B22554

SQ

4.0	D33737	Cam Lock
-----	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3373-7 Cam Lock B22944B22160

(62)

CHECK WITH PRODUCTION IF KEYED ALIKE OR UNALIKE

8/7/18

SQ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL LOCK

Job Number: 40190

Part Number: D3368041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D33853

Hinge



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3385-3

Hinge

B22387

sd

6.0

238028

3/16" Dowel Pin .5" long



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description Batch

3 238-028

Ø3/16" Dowel Pin 1/2" long

M16988

M17278

sd

7.0

385039

8-32 Flat screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description Batch

4 385-039

Flat Head Screw

M107150

sd

8.0

D33841

Cyclic Sock



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3384-1

Cyclic Sock

B37172

sd

9.0

CBL460

Loop Sleeve



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 CBL-460

Loop Sleeve

M106234

8/7/18

sd

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Drawing Name: PEDAL LOCK

Job Number: 40190

Part Number: D3368041

Job Number:



Seq. #:

Machine of Operation:

Description:

10.0

CBL1240

Cable



(6X)

Comment: Qty.: 2.3333 f(s)/Unit Total: 9.3332 f(s)

Pick:

Qty Part Number Description Batch
28" CBL-1240 Cable M103927

SP

11.0

AN960416

Washer



(6X)

Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 AN960-416 Washer M5519

SP

12.0

HX81

1/4"-20 SHCS 3/8" long



(6X)

Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 HX-81 1/4"-20 SHCS 3/8" long M16971 8/1/18

SP

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Open D3373-7 lock package. Keep keys, lock body, lock body nut, screw, flat cam and lock barrel.
Discard the rest.

2-Fabricate D3371-5 Cam Lock as per Dwg D3371 Identify as D3371-5

3-Assemble lock mechanism and cam and install decal as per Dwg D3368. Apply 262 locktite to lock body nut. Ensure mechanism works properly (open/close).

Pick:

Qty Part Number Description Batch
A/RN/A 262 Locktite M107045

4-Assemble lanyard to cyclic sock as per Dwg D3384

5-Assemble D3384-047 to D3368-051 using 1/4"-20 socket head cap screw and washer as per Dwg D3368

6-Ensure that keys are attached to D3368-041

EP 08/07/23 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/03 (46)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

P 8/7/04 (6)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/24/0

Job Completion



MF 08-07-24

C346A 20
C420A 40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

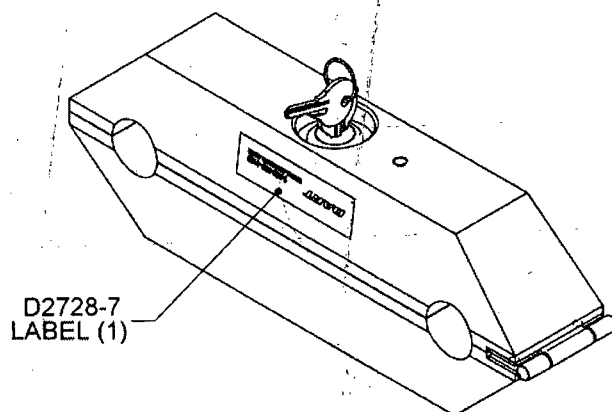
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 13	APPROVED 13	DRAWING NO. D3368	REV. B SHEET 1 OF 3
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:3
A	05.01.19	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	



RELEASED

25/04/28

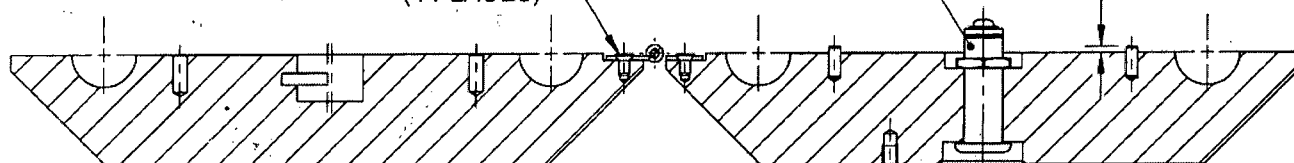
D2728-7
LABEL (1)

PEDAL LOCK SHOWN LOCKED WITH KEY

MACHINE SCREW
#8-32 x 0.313 LONG
(4 PLACES)

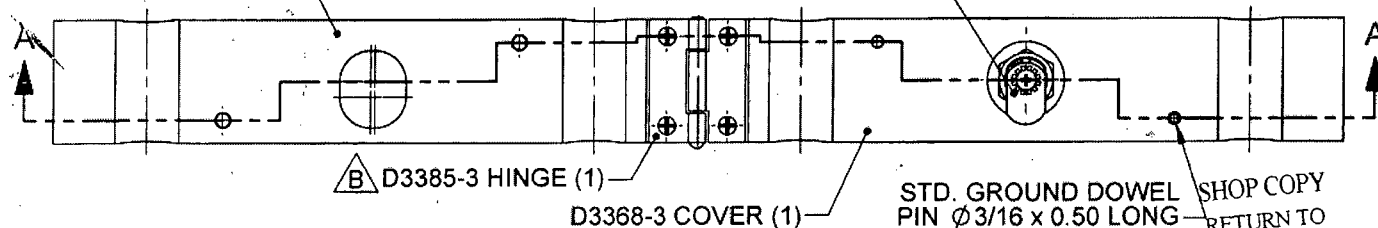
D3373-7 CAM
LOCK ASS'Y

0.100 (2 PLACES)



SECTION A-A

D3368-1 BASE (1)
D3371-5 CAM (1),
SQUARE WASHER SPACER (1),
EXTERNAL TOOTH LOCK WASHER (1),
#10-32 UNF PAN CROSS HEAD SCREW (1),
(AS PER DRAWING D3373)



D3385-3 HINGE (1)

D3368-3 COVER (1)

STD. GROUND DOWEL
PIN $\phi 3/16$ x 0.50 LONG
(2 PLACES)

SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 40190

D3368-051 PEDAL LOCK ASSEMBLY

NOTES:

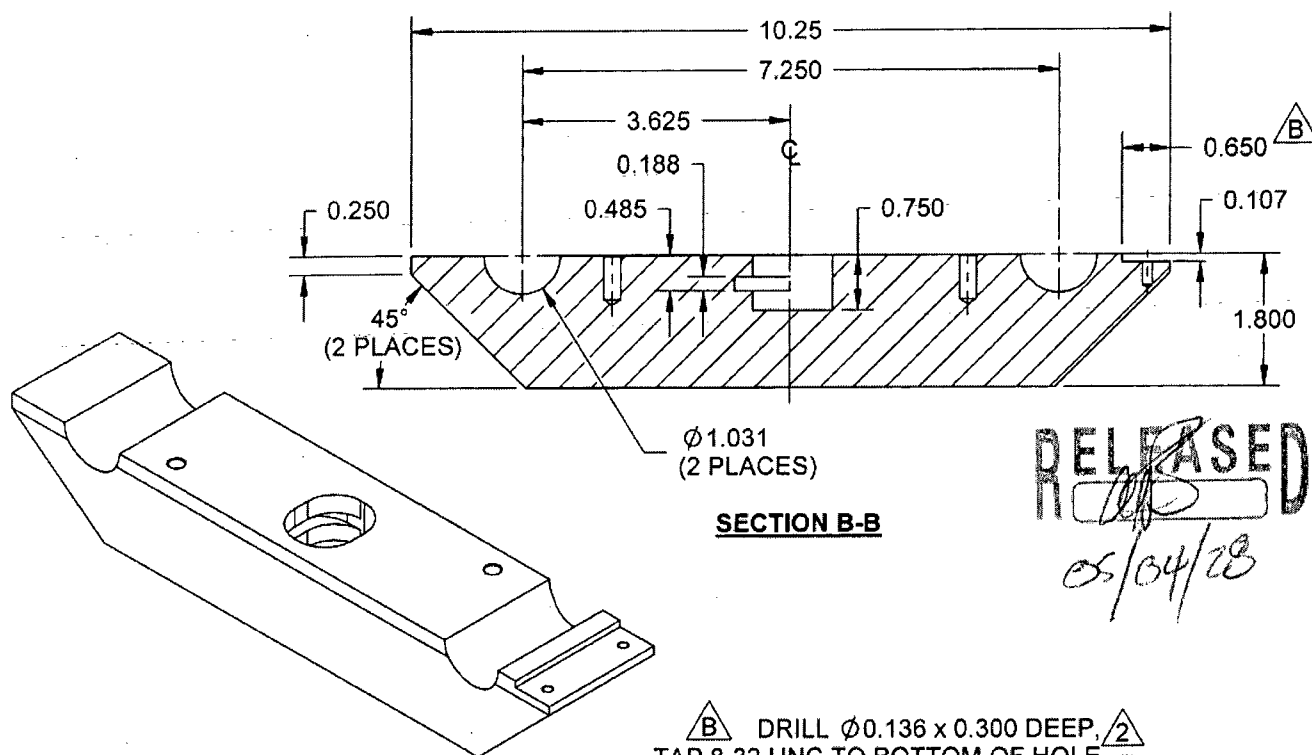
- 1) POSSIBLE SUPPLIER: SPAENAU P/N 385-044
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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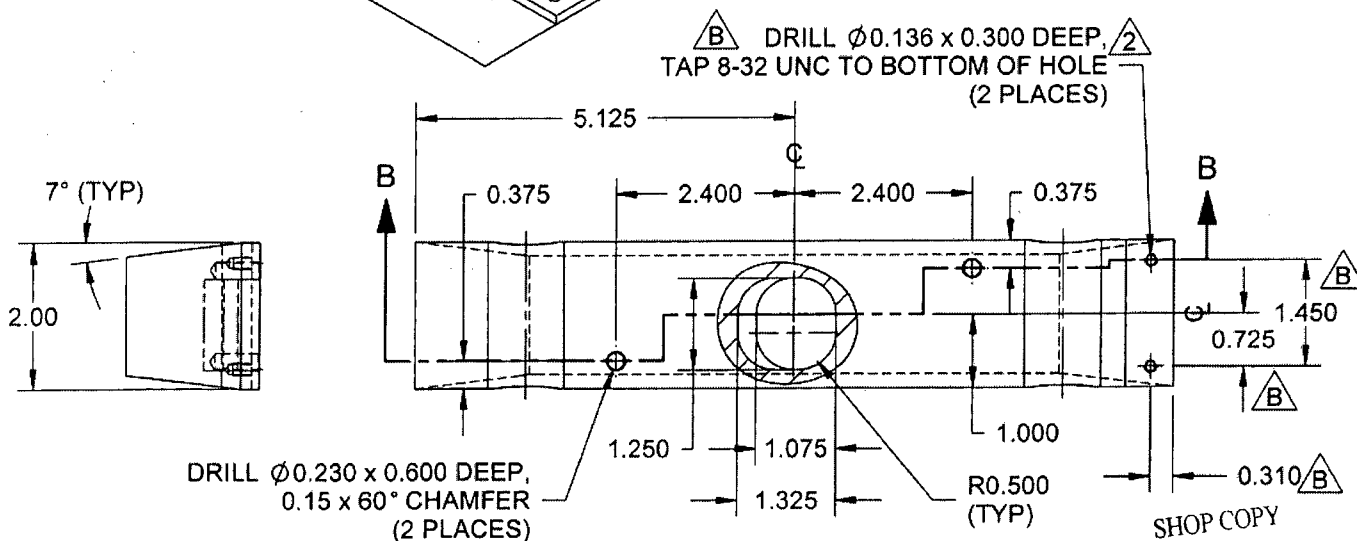


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3368	REV. B SHEET 2 OF 3
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:2.5



SECTION B-B

RELEASED
[Signature]
05/04/28



D3368-1 BASE

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

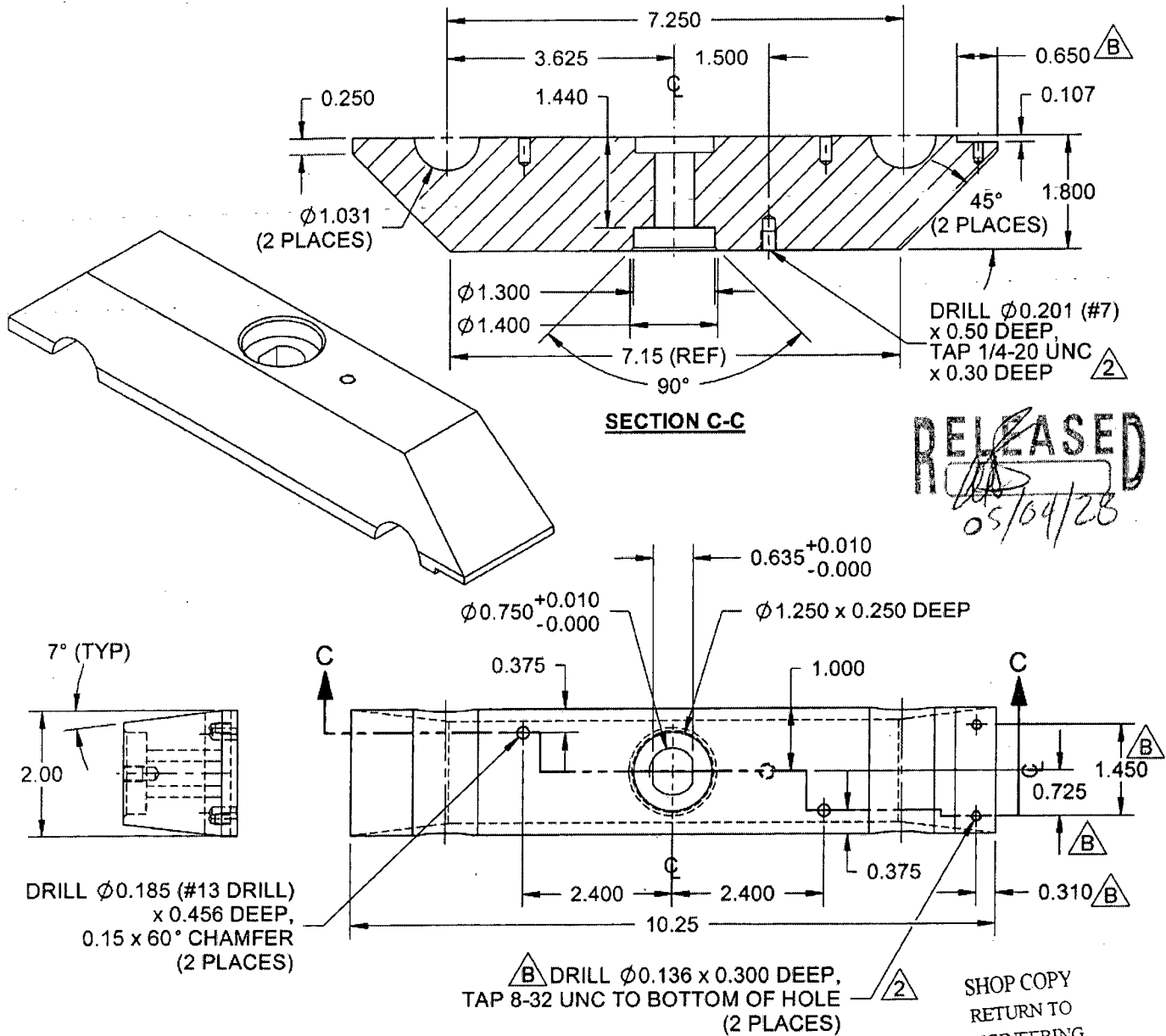
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3368	REV. B SHEET 3 OF 3
DATE 05.03.22	TITLE PEDAL LOCK	SCALE 1:2.5	



D3368-3 COVER

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

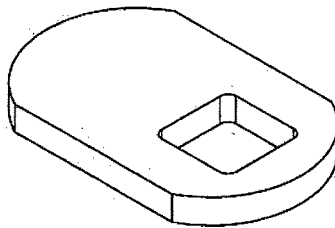
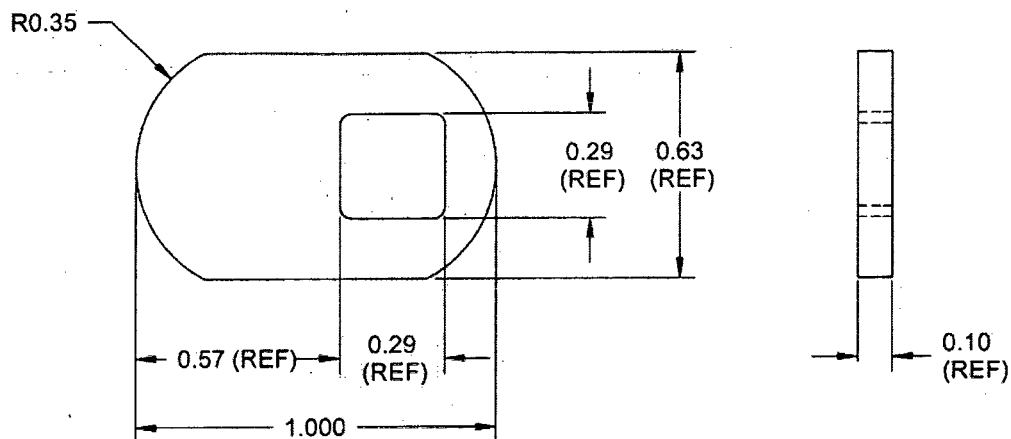
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DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 4 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 2:1

RELEASED
[Signature]
05/04/22**SPECIFICATION CONTROL DRAWING****D3371-5 CAM****NOTES:**

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WORK ORDER
NO. 40190

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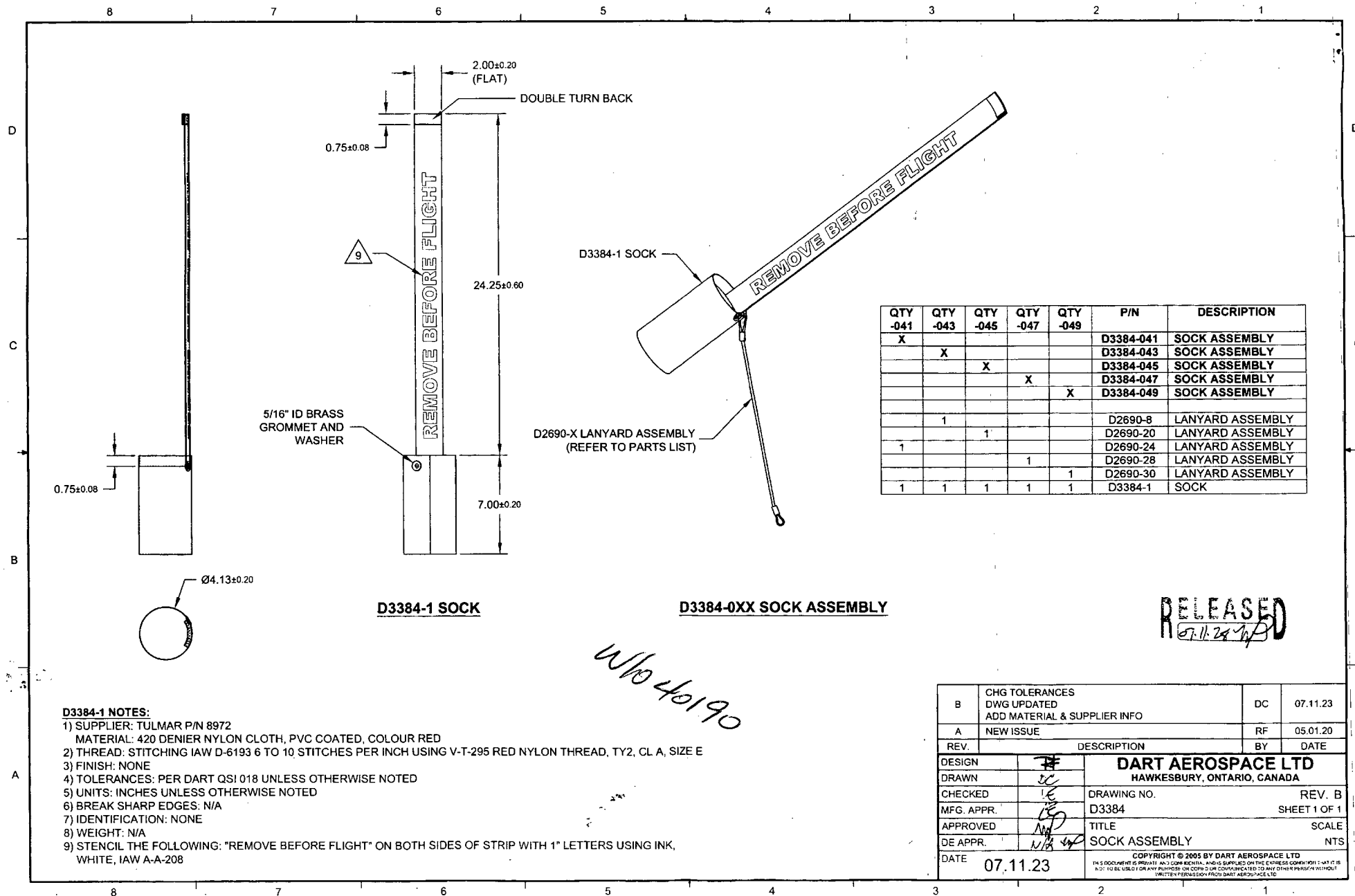
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	P/N	DESCRIPTION
X					D3384-041	SOCK ASSEMBLY
	X				D3384-043	SOCK ASSEMBLY
		X			D3384-045	SOCK ASSEMBLY
			X		D3384-047	SOCK ASSEMBLY
				X	D3384-049	SOCK ASSEMBLY
					D2690-8	LANYARD ASSEMBLY
					D2690-20	LANYARD ASSEMBLY
					D2690-24	LANYARD ASSEMBLY
					D2690-28	LANYARD ASSEMBLY
					D2690-30	LANYARD ASSEMBLY
					D3384-1	SOCK

RELEASED
07.11.23

B	CHG TOLERANCES DWG UPDATED ADD MATERIAL & SUPPLIER INFO	DC	07.11.23
A	NEW ISSUE	RF	05.01.20
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. B
CHECKED		D3384	SHEET 1 OF 1
MFG. APPR.		TITLE	SCALE
APPROVED		SOCK ASSEMBLY	NTS
DE APPR.		DATE 07.11.23	
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